

Work Order ID 146230

Friday, May 13, 2016 9:01:26 AM

146230

Page 1

Item ID: D5311-7

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Prop Rod

Start Date: 5/17/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/31/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MLSDate: MAY 13 2016

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5311	B

110

0.00

110

Small Fab

Memo

0.00

Small Fab

1- CUT AT 12.00"

2- PUNCH ONE END AS SPEC CONTROL DWG (SEE NOTE8)

3- TRIM OFF ACCESS MATERIAL AS PER DWG.

4- DRILL HOLE AS PER DWG AND DEBURR

6 FF JUN 09 2016

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

(6) DAS
38
9-88

JUN 10 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>W/401</i>	0.00				<i>6</i>	<i>2</i>	<i>6-613</i>	
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140						<i>MCS</i>		JUN 14 2016	
QC	Memo	0.00							
Quality Control									

MCS **JUN 14 2016**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : ☐							

Picklist Print

Friday, May 13, 2016 9:01:30 AM

Page 1

Work Order ID: 146230

146230

Parent Item: D5311-7

D5311-7

Parent Item Name: Prop Rod

Start Date: 5/17/2016

Required Date: 5/31/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IIN REV:A 16.02.10 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TR0.750W.049

Purchased

No

f

202.1576

6.315789

M304TR0 750W 049

FF JUN 09 2016

304 RD Tube .750 x .049W

Location

Loc Qty

Loc Code

GA002 134824

196.5848232

2.105263

M132270

0.00001

M133131

0.0007242

M133509

14.210211

M133700

8.85327

M133914

5.98516

M134138

1.1364496

M134212

9.8302125

M134306

41.2895779

M134528

62.890263

M134604

52.388945

~~2.105263~~ 4.210526

MAT

5.5727347

M133400

5.5727347

DQA: _____ Date: _____



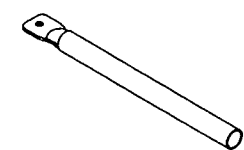
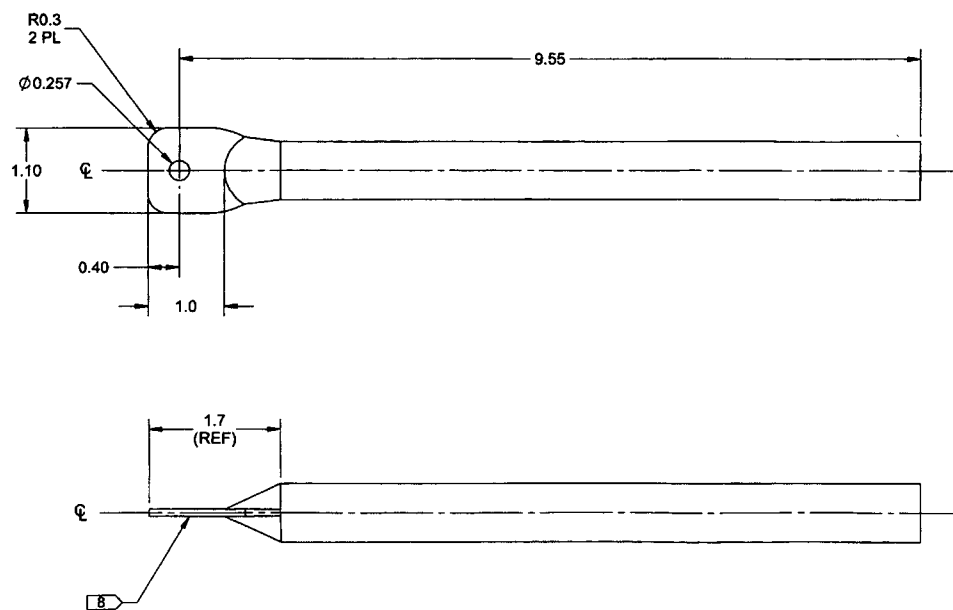
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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						



SECRET
 REF ID: A66666
 UNCONTROLLED
 SUBJECT: D5311
 WORK NO. 146230 M15
 1605-13

D5311-7 PROP ROD

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SEAMLESS ROUND TUBING
 PER ASTM A276 OR ASME SA213 OR ASTM A269
 REF DART SPEC M304TR0.750W.049
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.35 lbs
 - 8) PUNCH END USING TOOL NUMBER DT8117. TRIM, DRILL NEW HOLE AND FORM CORNERS AS REQUIRED

RELEASED
 2016-04-18

APPROVED

DESIGN	AK	DART AEROSPACE LTD	
DRAWN	AK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CC	DRAWING NO. D5311	REV. B
MFG. APPR.	DD	SHEET 5 OF 5	
APPROVED	HS	SCALE	
DE APPR.	DSS	TITLE ENGINE COWL SWIVEL PROP ROD NTS	
DATE	16.02.17	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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INSPECTION SHEET

DAS

30

Date:

Revised by